



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 63791

Monday, November 15, 2010 8:29:33 AM



Page 2

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 11/12/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00

SL

10/12/06



QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PP 63792

0.00

Packaging

10/12/06 (10)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/06

MF 10-12-06

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 15, 2010 8:29:37 AM

Page 1

Work Order ID: 63791



Parent Item: D2432

Parent Item Name: 206 (24") Bec. paw

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 10.00

Required Qty: 10.00

## Comments:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MUHMWB10

Purchased

No

120

sf

183.2114

3.7

37



UHMW 1" Black



B10-11-17

### Location

### Loc Qty

### Loc Code

MAT

183.2114

114624

5.9054

115325

15.506

115955

161.8

115955

(10)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|   |  |                     |       |
|---|--|---------------------|-------|
| <b>DART AEROSPACE LTD</b>                   |  | <b>Work Order:</b>  | 63791 |
| <b>Description:</b> Bearpaw                 |  | <b>Part Number:</b> | D2432 |
| <b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3 |  | <b>Page 1 of 1</b>  |       |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

| Inspection Sheet<br>Drawing Dimension |             | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|-------------|---------------|---------------------|--------|--------|-------------------------|----------|
| A                                     | 0.063 x 45° | +0.030/-0.010 | .055X45°            | —      |        | Vern                    | ML-7     |
| B                                     | 5.500       | +/-0.030      | 5.505               | —      |        | "                       | "        |
| C                                     | 0.200       | +/-0.030      | .203                | —      |        | "                       | "        |
| D                                     | 0.25 x 45°  | +/-0.030      | .237X45°            | —      |        | "                       | "        |
| E                                     | R0.250      | +/-0.030      | R.250               | —      |        | Rad-gage                | REF      |
| F                                     | 0.250       | +/-0.010      | .252                | —      |        | Vern                    | ML-7     |
| G                                     | 0.625       | +/-0.030      | .630                | —      |        | "                       | "        |
| H                                     | 0.375       | +/-0.010      | .385                | —      |        | "                       | "        |
| I                                     | 0.950       | +0.030/0.010  | .962                | —      |        | "                       | "        |
| J                                     | 19.000      | +/-0.030      | 19.000              | —      |        | M-tape                  | ML-2     |
| K                                     | 3.14        | +/-0.030      | 3.145               | —      |        | Vern                    | ML-7     |
| L                                     | 3.28        | +/-0.030      | 3.288               | —      |        | "                       | "        |
| M                                     | Ø0.260      | +0.005/-0.000 | Ø.260               | —      |        | "                       | "        |
| N                                     | Ø0.93       | +/-0.030      | Ø.925               | —      |        | "                       | "        |
| O                                     | 0.30        | +0.030/-0.000 | .301                | —      |        | "                       | "        |
| P                                     | 23.750      | +/-0.030      | 23.750              | —      |        | M-tape                  | ML-2     |
| Q                                     | 7.375       | +/-0.030      | 7.375               | —      |        | "                       | "        |
| R                                     | 4.250       | +/-0.010      | 4.250               | —      |        | "                       | "        |
| S                                     | 2.000       | +/-0.030      | 2.000               | —      |        | "                       | "        |
| T                                     | 9.000       | +/-0.010      | 9.000               | —      |        | "                       | "        |
| U                                     | 9.000       | +/-0.010      | 9.000               | —      |        | "                       | "        |
| V                                     | 0.375       | +/-0.010      | .381                | —      |        | Vern                    | ML-7     |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |

|                     |           |                    |           |                            |     |
|---------------------|-----------|--------------------|-----------|----------------------------|-----|
| <b>Measured by:</b> | <i>ML</i> | <b>Audited by:</b> | <i>SL</i> | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | 10/12/02  | <b>Date:</b>       | 10/12/06  | <b>Date:</b>               |     |

| Rev | Date     | Change    | Revised by              | Approved |
|-----|----------|-----------|-------------------------|----------|
| A   | 04.01.09 | New Issue | P/O K10008/D206-559-015 | KJ/RF    |

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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

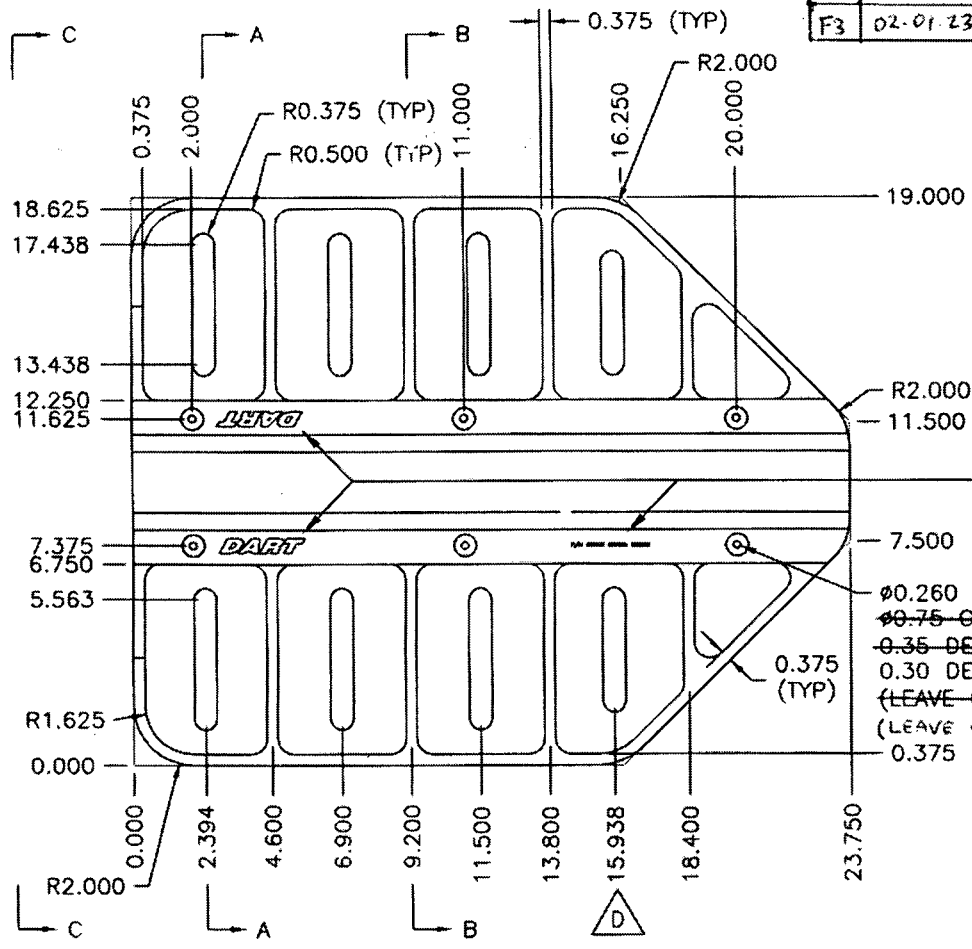
**NOTE:** Date & initial all entries



|    |          |                               |
|----|----------|-------------------------------|
| F1 | 99.03.03 | ADD DEC 9143                  |
| F2 | 01.03.28 | <del>Ø0.93 WAS Ø0.75</del> RF |
| F3 | 02.01.23 | CLARIFY CORE DIMS RF          |

**RELEASED**  
99.06.17 KE

SH...  
RE...  
ENG...  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITH NOTICE  
WORK ORDER  
NO. 3291  
*10-11-15*



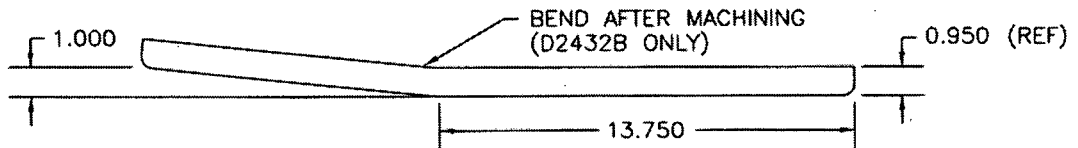
ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)  
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375

F2  
F1  
F  
F1

| EFFECTIVE | DEOS |
|-----------|------|
| 9143      |      |

FLAT PATTERN



D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

| DESIGN           | DRAWN BY       | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
|------------------|----------------|---|------------------------|
| KE<br>CHECKED    | KE<br>APPROVED | DRAWING NO.<br>D2432                              | REV. F<br>SHEET 1 OF 2 |
| DATE<br>98.05.12 |                | TITLE<br>BEARPAW                                  | SCALE<br>1:6           |
| A                | 95.10.31       | NEW ISSUE   |                        |
| B                | 96.01.24       | RE-DESIGN   |                        |
| C                | 96.03.26       | CHANGE BORE AND C'BORE DEPTH                      |                        |
| D                | 96.06.04       | MOVE SLOT   |                        |
| E                | 97.02.27       | CHANGE C'BORE DEPTH, BORE RADIUS                  |                        |
| F                | 98.05.12       | CHANGE C'BORE, ADD B AND F P/N                    |                        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

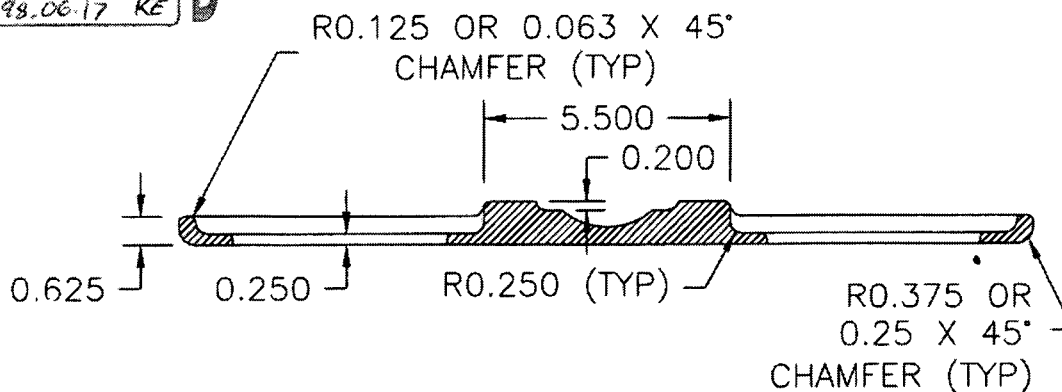
**NOTE:** Date & initial all entries



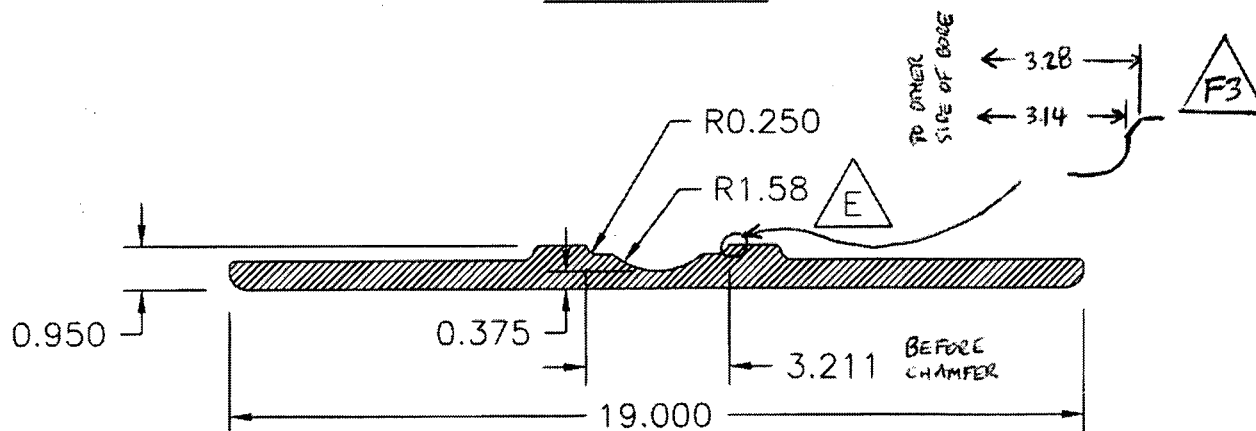
|                  |                         |   |                        |
|------------------|-------------------------|---|------------------------|
| DESIGN<br>KE     | DRAWN BY<br>KE          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>MAY   | APPROVED<br>[Signature] | DRAWING NO.<br>D2432                              | REV. F<br>SHEET 2 OF 2 |
| DATE<br>98.05.12 | TITLE<br>BEARPAW        |   | SCALE<br>1:4           |

RELEASED  
98.06.17 KE

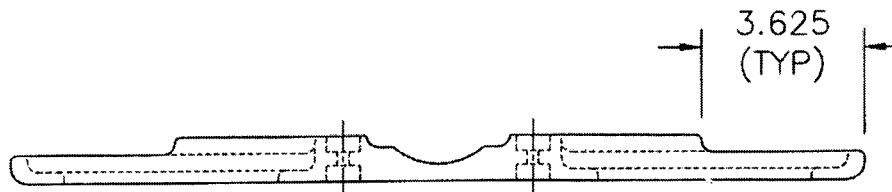
u63791



SECTION A-A



SECTION B-B



SECTION C-C

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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